

Date: Wednesday, 1/18/2006 4:05:38 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 25557E		
Estimate Number	: 10283		
P.O. Number	: N/A	Part Number	: D31991
This Issue	: 1/18/2006 S.O. No. : N/A	Drawing Number	: D3199 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 25556E	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 2/15/2006
Checked & Approved By	: SEE ABOVE USER & DATE	Qty:	36 Um: Each
Comment	: Est Rev:C Removed Scribing 05-11-05 JLM		

## Additional Product

Job Number:

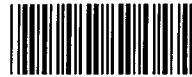


Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 00000450

06/01/26

Email or Ship DXF file to vendor

Laser Cut D3199-1 bracket per Dwg D3199

Material release note is required

2.0

D31991F

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 36.0000 Each(s)

Bracket

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

C 206/03/09

50

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

060314

50

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary SAD 06/03/20

2-Form as per Dwg D3199 N/A - Already Formed.

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 1 Date: 06/03/23

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:05:39 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 25557E

Part Number: D31991

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*06/03/20*

\$

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*06/03/20 (50)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*06/03/21 (50)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 138

*06/03/21 (50)*

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/03/23 (50)*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

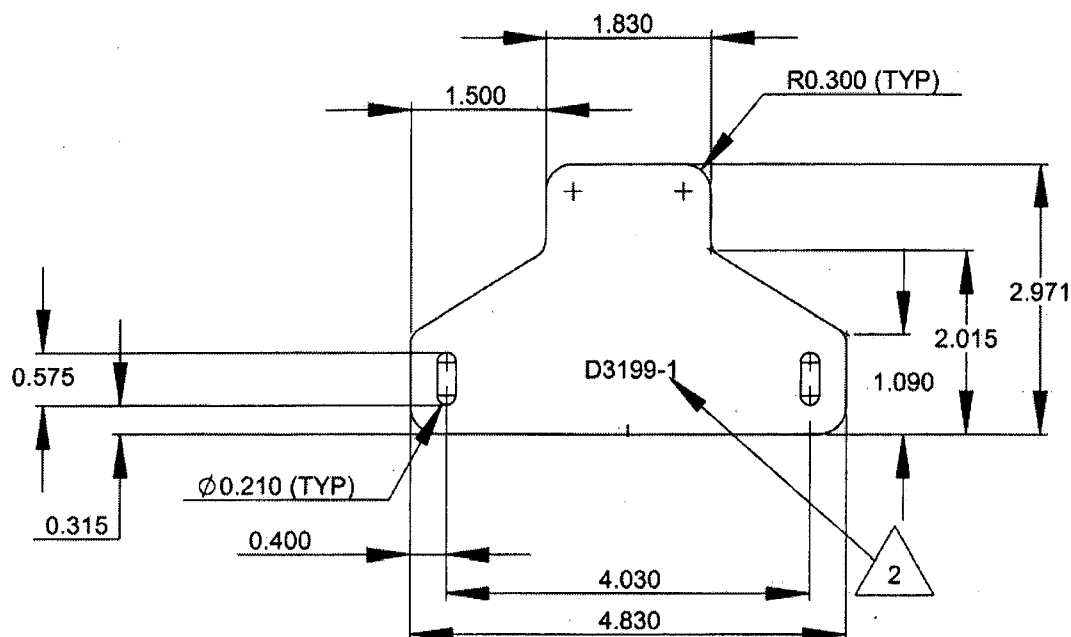
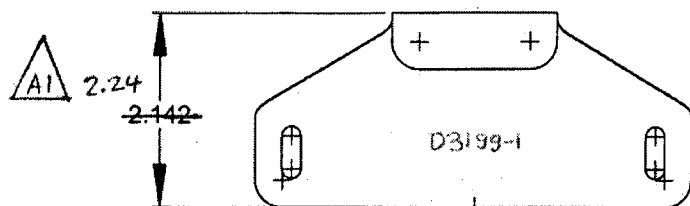
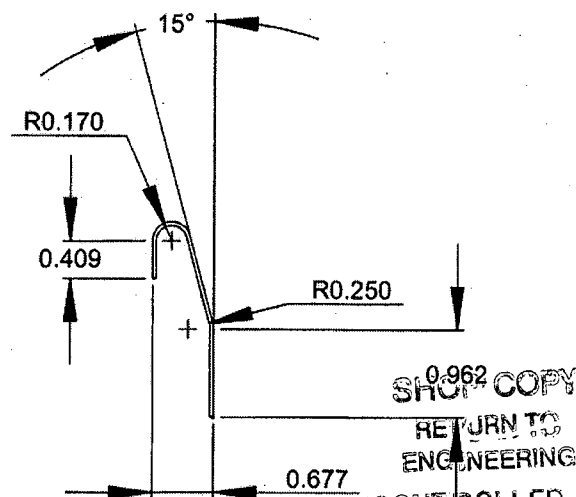
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	CP	DRAWN BY	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. <b>D3199</b> REV. A SHEET 1 OF 1
DATE	03.08.05	TITLE	BRACKET	SCALE 1:2
A	03.08.05	NEW ISSUE		
AI	04.03.01	#	2.24 WAS 2.142	

**RELEASED**  
03.09.02**D3199-1 FLAT PATTERN****D3199-1 BRACKET****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) SCRIBE DART P/N D3199-1 AS SHOWN.
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES.

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WORK COPY

NO 25557E

OLBERT METAL SALES LIMITED